

Work Order ID 73125

Friday, August 26, 2011 6:30:43 AM



Page 1

Item ID: D206-642-541

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 8/26/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 9/9/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: MF

Date: 11-08-29

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3274

D

IIN-D206-642

Rev M

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D206-642-541

CHG003

N/A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

110

0.00



Skidtubes

Skidtubes

Memo

0.00

****VERIFY AND INSPECT THE MATERIAL PRIOR TO USE****

1- Bend FWD end of tube using bend prog D3274 FWD and foil 10 as per dwg D3274, cut fwd end of tube with saw table setup D3274.

2- remove fwd indexing ridge as per dwg D3274. Prepare for welding

3- weld fwd cap as per dwg D3274 and QSI004
AR Aluminum Rod Batch: m112860

4- grind fwd cap weld on top surface only

5- Cut AFT end of tube at 170.9" as per dwg D3274 and deburr end.

6-Drill Aft cap pilot hole using DT8025

7 -Cleco DT8025 in position and install pilot hole drill Jig DT8742A,B,C,D.
Drill 3/16" pilot holes as per Dwg D32748 -Remove inner indexing ridge on aft end of skidtube as per Dwg D3274 scribe
batch #

9 -Open aft end cap holes to Ø0.208" as per Dwg D3274. Deburr aft end.

DP

11-9-14

DL 11/09/15

BE 11/09/15

DL 11/09/15

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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

114

QC5- Inspect part completeness to step on W/O

0.00

8 w/09/20



QC

Memo

0.00

Quality Control

116

QC10- Inspect visual per QSI004- ground welds

0.00

8 w/09/20



QC

Memo

0.00

Quality Control

(40)

120

Chemical Conversion Coat per QSI005 4.1

0.00

JW



HandFinish

Memo

0.00

Hand Finishing

11-09-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Customer:

Reference:

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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control



11-9-26

150

Skidtubes

0.00



Skidtubes

Memo

0.00

Skidtubes

1-Open Ø0.313" and 0.375" crossbolt spacer holes as per Dwg D3274

2-Deburr crossbolt spacer holes as per Dwg D3274 and blow out chips from inside the tube

3-Bond web in place as per Dwg D3274 & QSI 015.

A/R ☐ Sikaflex-291 ☐ 118393 ☐Sikaflex expire date: ☐ 12/04/05 ☐Start: ☐ 2:45 ☐ Time: ☐Finish: ☐ 11/19/12 ☐ Time: ☐ 9:00

(Adhere for 12 hours)

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

DP

11-10-6

170

Skidtubes

0.00



Skidtubes

Memo

0.00

Skidtubes

1-Bend AFT end of tube using bend prog. D3274 AFT as per dwg D3274. Install drop pins in crossbolt spacer holes to maintain web position.

2- DRILL PILOT HOLES FOR WEARPLATES USING D3274-1T2
OPEN HOLES TO .297" . Deburr3-DRILL TOE PIN HOLE .640" DIA AS PER DWG USING DT8935 FWD
END OF TUBE
DEBURR INSIDE OF HOLE AS NECESSARY (DO NOT ENLARGE HOLES)
REMOVE ANY FOREIGN OBJECTS INSIDE OF TUBES

4- Countersink crossbolt spacer holes as per Dwg D3274

5- prepare for welding

DP

11-10-6

B

11/10/11

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC5- Inspect part completeness to step on W/O

0.00

3.03⁷¹4.7⁰

QC

Memo

0.00

Quality Control

1 0 BE 11/10/12

190

Skidtubes

0.00



Skidtubes

Memo

0.00

Skidtubes

1-Insert D2649 & D3275-1 crossbolt spacers. Weld as per QSI 004 and Dwg D3274. Remember to back drill each hole before welding the other side. Use aluminum rod

A/R ☐ Aluminum Rod ☒ M117884

BE 11/10/12

3-Grind cross bolt welds flush as per Dwg D3274.

BB 11/10/13

4-Counterbore 5/16" x 0.750" deep as per Dwg D3274 and deburr.

DP 11-10-13

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

200

QC5- Inspect part completeness to step on W/O

0.00

8/11/10/13



QC

Memo

0.00

Quality Control

210

QC10- Inspect visual per QSI004- ground welds

0.00

8/11/10/13



QC

Memo

0.00

Quality Control

220

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch

IXY m-f 11/10/17

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

230	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
-----	--	------	--	--	--	--	--	--	--



Powdercoat

Powder Coating

Memo
START TIME: 1:30
OVEN TEMPERATURE: 320°F
FINISH TIME: 2:00

1X M-L 11/10/17

240	QC3- Inspect Part Finish	0.00							
-----	--------------------------	------	--	--	--	--	--	--	--



QC

Memo

Quality Control

1 BL 11-10-19

250	HandFinishing	0.00							
-----	---------------	------	--	--	--	--	--	--	--



HandFinish

Hand Finishing

Memo

1-Install Nut Plate as per Dwg D3274. Apply LPS-3 to Nut Plate and rivets.
A/R ☐ N/A ☐ LPS-3 ☒ 14596.

2-Install inserts as per Dwg D3274. Use a drop of Sikaflex inside insert holes a
A/R ☐ ☐ Sikaflex-291 ☒ 118398 ☐
Sikaflex expire date: ☒ P-5

1 BL 11-10-19

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

260

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Inspect Nut Plate & Inserts

11/10/19

270

HAND FINISHING RESOURCE #1

0.00



HandFinish

Memo

0.00

Hand Finishing

1-Install wearpads & gaskets as per Dwg D3274.

2-Install ring as per Dwg D3274

A/R ☐ Sikaflex-291 ☐ *118393* ☐Sikaflex expire date: ☐ *12-3*

3-Inspect for foreign objects as per QSI 024

4-Spray inside of tube on both sides of web with LPS-3

A/R LPS-3 Batch: *N/A.*

5-Install Aft Cap and seal with Sikaflex. Clean excess adhesive.

A/R ☐ Sikaflex-291 ☐ *118393* ☐Sikaflex expire date: ☐ *12-5**1 11-10-19**PROCTON, 114596.*

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

280

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

8/16/11

Quality Control



290

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

0.00

Packaging

PPP 73211

Sp 11-10-20

300

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/10/24

11-10-20

W/O:		WORK ORDER CHANGES					
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Picklist Print

Friday, August 26, 2011 6:30:40 AM

Page 1

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Parent Item: D206-642-541

Parent Item Name: Replacement Skidtube


Start Date: 8/26/2011

Required Date: 9/9/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:B 05.09.23 Revised per D206-642 Rev. J KJ/JLM
IPP Rev:C 07-02-23 Added SS Wearplates & Gaskets JLM
IPP Rev:D 07-12-06 replace NAS1515H3L to D3672-1 DD
IPP Rev:E 08-04-17 as per PAR 08-015 DD verified by:EC
IPP Rev:F 08-06-02 add comment DD verified by:EC
IPP Rev:G 08-10-09 revise details DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2600-1-190  Extrusion Round 3" 206		Manufactured	No			110	Each	81.4000	1	1			

Location

Loc Qty

Loc Code

HALL

81.4

22.4

59

D3285-1



Cap

Manufactured No

110

Each

92.0000

1

1

Location

Loc Qty

Loc Code

LG002

92

52511

45

52647

47

D3282-041



Float Web (206L/407)

Manufactured No

150

Each

2.0000

1

1

Location

Loc Qty

Loc Code

LG

70050

2

69714

2

1

11/09/2011

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Start Date: 8/26/2011

Required Date: 9/9/2011

Start Qty: 1.00

Required Qty: 1.00

D2649 Manufactured No 190 Each 46.0000 12 12
Cross Bolt Spacer

Location	Loc Qty	Loc Code
LG	34	
68224	2	
71355	2	
72704	30	
LG001	12	
65317	1	
68507	11	



BE 11/10/12
B 73857 *12

D3275-1 Manufactured No 190 Each 280.0000 12 12
Crossbolt Spacer

Location	Loc Qty	Loc Code
LG	161	
72123	161	
LG002	119	
66930	106	
68946	13	



BE 11/10/12
B 73393 *12

CR3212-4-03 Purchased No 250 Each 1,158.000 2 2
Cherry Rivet

Location	Loc Qty	Loc Code
FP-B	2	
110139	2	
ST311	1156	
114859	1156	



BR 11 10-12

Friday, August 26, 2011 6:30:40 AM

Shop Packet Print

Page 2

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Parent Item Name: Replacement Skidtube

Start Date: 8/26/2011

Required Date: 9/9/2011

Start Qty: 1.00

Required Qty: 1.00

D3415-041 Manufactured No

250 Each

50.0000

1

1



Nut Plate



BR 11-10-19

Location

Loc Qty

Loc Code

ST053

50

33842

6

67605 ✓

44

CCR264SS3-3

Purchased No

250 Each

459.0000

2

2



BR 11-10-19

Location

Loc Qty

Loc Code

FP-B

2

113973

2

ST311

457

117086

31

117849 ✓

426

ALS4-1032-130

Purchased No

250 Each

1,416.000

78

78



BR 11-10-19

Location

Loc Qty

Loc Code

ST281

370

118386

370

ST282

1046

117717

54

118237

736

118312

256

* ALS7-1032-130. 118966.

78

W/O:		WORK ORDER CHANGES					
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Start Date: 8/26/2011

Required Date: 9/9/2011

Start Qty: 1.00

Required Qty: 1.00

D3536-15 Manufactured No

270

Each

22.0000

1

1



Gasket



BR 11-10-19

Location

Loc Qty

Loc Code

FP011

22

71586 ✓

13

72881

9

D3536-23 Manufactured No

270

Each

18.0000

1

1



Gasket



BR 11-10-19

Location

Loc Qty

Loc Code

FP011

18

43406

1

69902

5

71579

12

D3536-35 Manufactured No

270

Each

23.0000

1

1



Gasket



BR 11-10-19

Location

Loc Qty

Loc Code

FP012

23

71587 ✓

13

72882

10

D3536-39 Manufactured No

270

Each

20.0000

1

1



Gasket



BR 11-10-19

Location

Loc Qty

Loc Code

FP015

20

69760 ✓

20

Friday, August 26, 2011 6:30:40 AM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, August 26, 2011 6:30:40 AM

Page 5

Work Order ID: 73125

Parent Item: D206-642-541

Parent Item Name: Replacement Skidtube

Start Date: 8/26/2011

Required Date: 9/9/2011

Start Qty: 1.00

Required Qty: 1.00

D3535-15
Wearshoe

Manufactured No

270 Each

9.0000

1

1

Location

Loc Qty

Loc Code

FP018

73006.
69931

9

9



1

BR 11-10-19

D3535-35
Wearshoe

Manufactured No

270 Each

12.0000

1

1

Location

Loc Qty

Loc Code

FP018

73311
65926
67598
70815

12

1

1

10



1

BR 11-10-19

D3535-39
Wearshoe

Manufactured No

270 Each

19.0000

1

1

Location

Loc Qty

Loc Code

FP018

69759
72159 ✓

19

6

13



1

BR 11-10-19

D3535-23
Wearshoe

Manufactured No

270 Each

18.0000

1

1

Location

Loc Qty

Loc Code

FP021

70818
71581 ✓

18

8

10



1

BR 11-10-19

Friday, August 26, 2011 6:30:40 AM

Shop Packet Print

Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, August 26, 2011 6:30:40 AM

Page 6

Work Order ID: 73125

Parent Item: D206-642-541

Parent Item Name: Replacement Skidtube

Start Date: 8/26/2011

Required Date: 9/9/2011

Start Qty: 1.00

Required Qty: 1.00

D3537-3

Manufactured No

270

Each

11.0000

1

1



Wearpad



BR 11-10-19

Location

Loc Qty

Loc Code

FP

72144

5

70481

5

FP017

6

35697

1

72686

5

1

D3537-1

Manufactured No

270

Each

66.0000

9

9



Wearpad



BR 11-10-19

Location

Loc Qty

Loc Code

FP001

73395

9

69530

9

FP016

74597

50

68944

0

70687

50

FP017

7

69817

5

70686

2

8

AN960C10L

* R

NAS1149C0332

Purchased

No

270

Each

0.0000

80

80



washer

118354



80

BR 11-10-19

AN960C416

* R

NAS1149C0463

Purchased

No

270

Each

0.0000

1

1



washer

117735



1

BR 11-10-19

Friday, August 26, 2011 6:30:41 AM

Shop Packet Print

Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, August 26, 2011 6:30:41 AM

Page 7

Work Order ID: 73125

Parent Item: D206-642-541

Parent Item Name: Replacement Skidtube

Start Date: 8/26/2011

Required Date: 9/9/2011

Start Qty: 1.00

Required Qty: 1.00

D3672-1

Manufactured No

270

Each

1,180.000

2

2



Phenolic Washer



BR 11-10-19.

Location

Loc Qty

Loc Code

ST074

1178

64177

182

66821 ✓

496

72229

500

ST077

2

52505

2

AN3C4A

Purchased

No

270

Each

2,125.000

80

80



BOLT



BR 11-10-19.

Location

Loc Qty

Loc Code

ST350

2125

117313

2

117688

36

117795

1

117872

22

118012

20

118112

40

118451 ✓

1000

118628

1004

AN4C5A

Purchased

No

270

Each

487.0000

1

1



BOLT



BR 11-10-19.

Location

Loc Qty

Loc Code

FP-B

98

112243 ✓

98

ST345

389

112243

389

Friday, August 26, 2011 6:30:41 AM

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Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, August 26, 2011 6:30:41 AM

Page 8

Work Order ID: 73125



Parent Item: D206-642-541



Parent Item Name: Replacement Skidtube

Start Date: 8/26/2011

Required Date: 9/9/2011

Start Qty: 1.00

Required Qty: 1.00

D2646

Manufactured No

270

Each

93.0000

1

1



Aft Cap



BR 11-10-19.

Location

Loc Qty

Loc Code

FP004

46

68280 ✓

46

FP006

5

62678

5

FP-4

38

70945

1

71070

37

fp5

4

71038

4

D3413-1

Manufactured No

270

Each

23.0000

1

1



Ring



BR 11-10-19.

Location

Loc Qty

Loc Code

ST420

23

66387

1

70773

22

73298.

Friday, August 26, 2011 6:30:41 AM

Shop Packet Print

Page 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

RELEASED

07.02.12

DEO ATTACHED

DESIGN CP	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3274	REV. D SHEET 1 OF 4
DATE 06.12.19		TITLE SKIDTUBE ASSEMBLY	SCALE NTS
A	04.03.15	NEW ISSUE	
B	04.08.09	MOVE SADDLE HOLE: 42.14 WAS 42.76	
C	05.03.16	ADD -043; NEW INSERTS	
D	06.12.19	NEW INSERTS, SS WEARSHOE + GASKET	

Qty -041	Qty -043	Part Number	Description
X		D3274-041	SKIDTUBE ASSEMBLY
	X	D3274-043	SKIDTUBE ASSEMBLY
1	1	D2600-1-240	EXTRUSION
1	1	D2646	AFT CAP
12	12	D2649	CROSS BOLT SPACER
12	37	D3275-1	CROSS BOLT SPACER
1	1	D3282-041	FLOAT WEB
1	1	D3285-1	CAP
1	1	D3413-1	RING
1	1	D3415-041	NUT PLATE
1	1	D3535-15	WEARSHOE
1	1	D3535-23	WEARSHOE
1	1	D3535-35	WEARSHOE
1	1	D3535-39	WEARSHOE
1	1	D3536-15	GASKET
1	1	D3536-23	GASKET
1	1	D3536-35	GASKET
1	1	D3536-39	GASKET
9	9	D3537-1	WEARPAD
1	1	D3537-3	WEARPAD
78	78	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
80	80	AN3C4A	BOLT
1	1	AN4C5A	BOLT
1	1	AN960C416	WASHER
80	80	AN960C10L	WASHER
2	2	CCR264SS3-3	RIVET
2	2	CR3212-4-03	RIVET
2	2	NAS1515H3L	WASHER

GENERAL NOTES:

1. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
2. DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 7 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
3. ALL HOLES DRILLED ON CENTERLINES.
4. BOND D3282-041 FLOAT WEB INTO D3274-1/-3 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015. ENSURE HOLES LINE-UP.
5. WELDING TO BE DONE PER DART QSI 004.
6. FINISH: - ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1
- POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
7. DRILL Ø0.297 HOLES FOR ALS7-1032-130 INSERTS USING DT3274-1T2 BEFORE FINISH. INSTALL ALS7-1032-130 INSERTS AFTER FINISH. SEAL WEARSHOE BOLTS WITH SIKAFLEX -241/-291.
8. SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

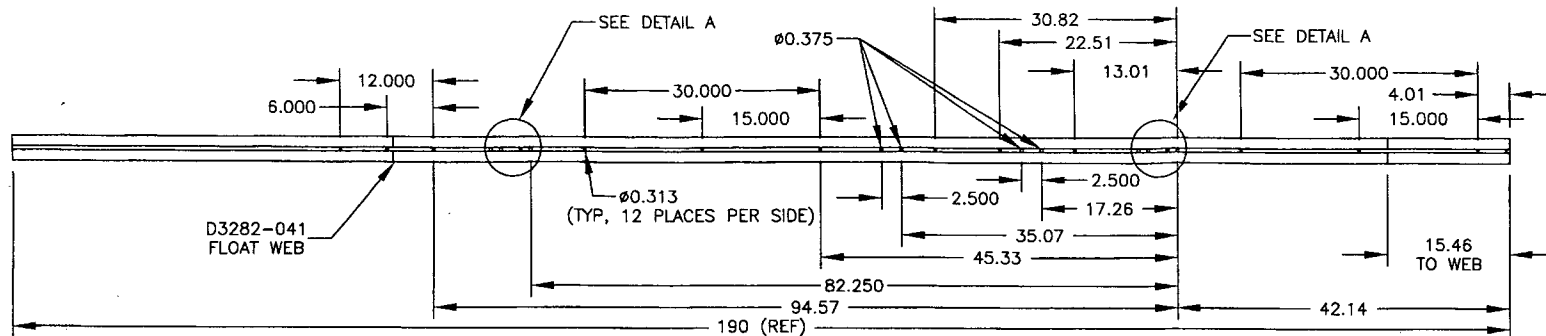
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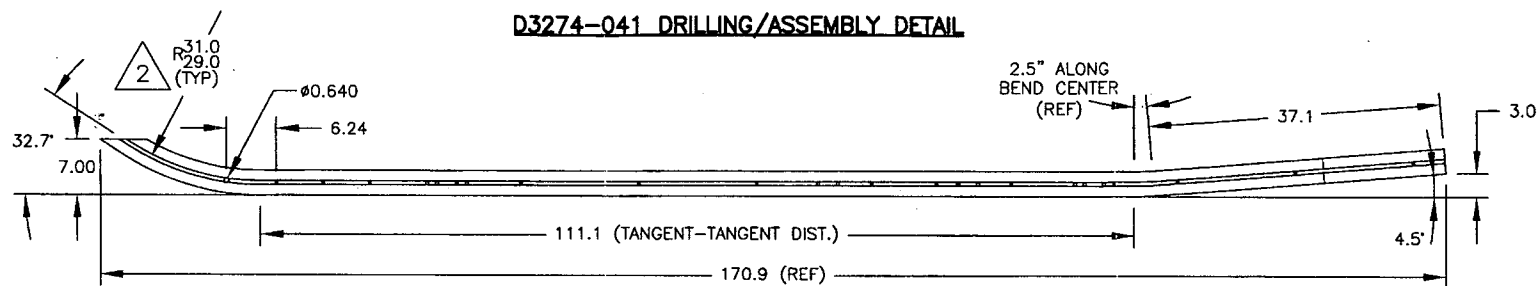
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

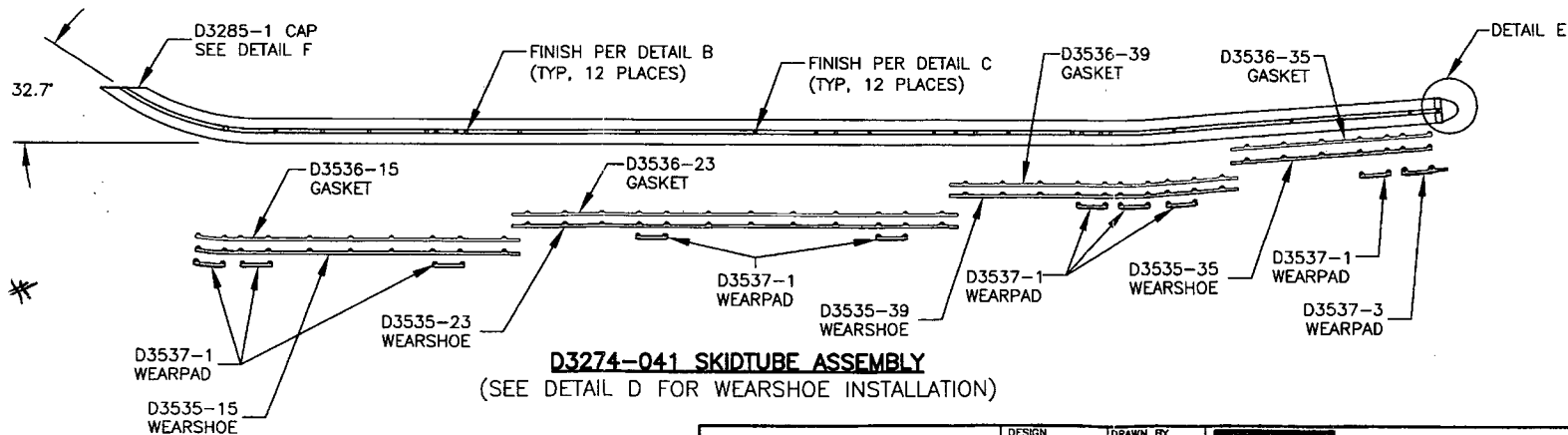
DEO ATTACHED



D3274-041 DRILLING/ASSEMBLY DETAIL



D3274-041 BEND/DRILLING DETAIL



D3274-041 SKIDTUBE ASSEMBLY
(SEE DETAIL D FOR WEARSHOE INSTALLATION)

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DESIGN CP	DRAWN BY AH	DART DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED #	APPROVED #	DRAWING NO. D3274
DATE 06.12.19	TITLE SKIDTUBE ASSEMBLY	REV. D SHEET 2 OF 4 SCALE 1:15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

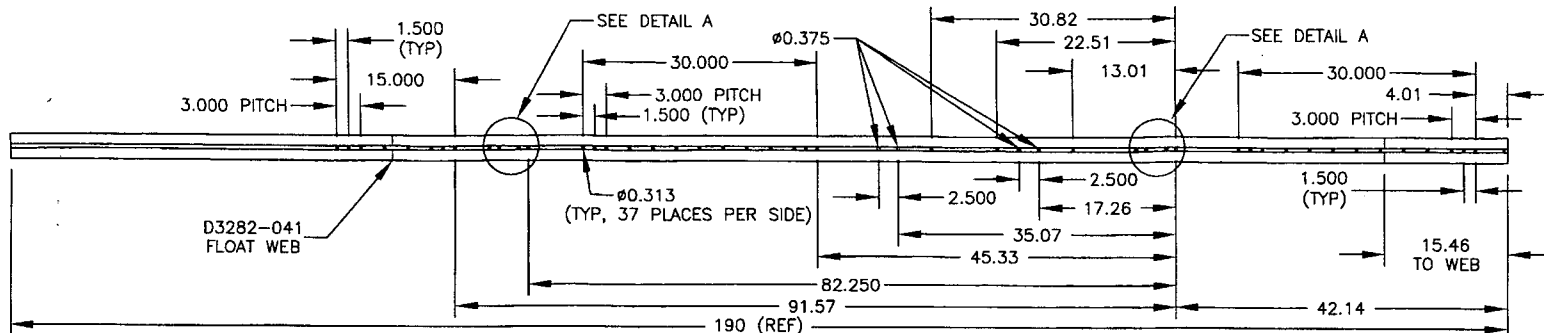
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

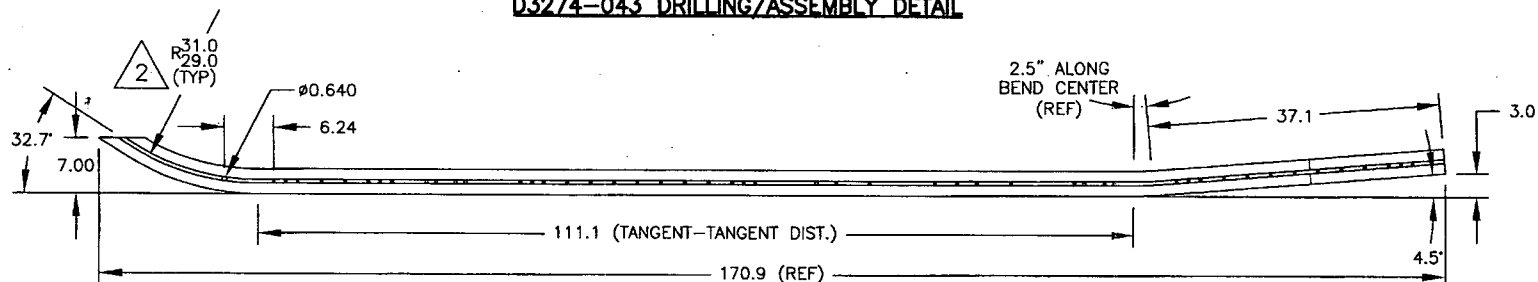
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

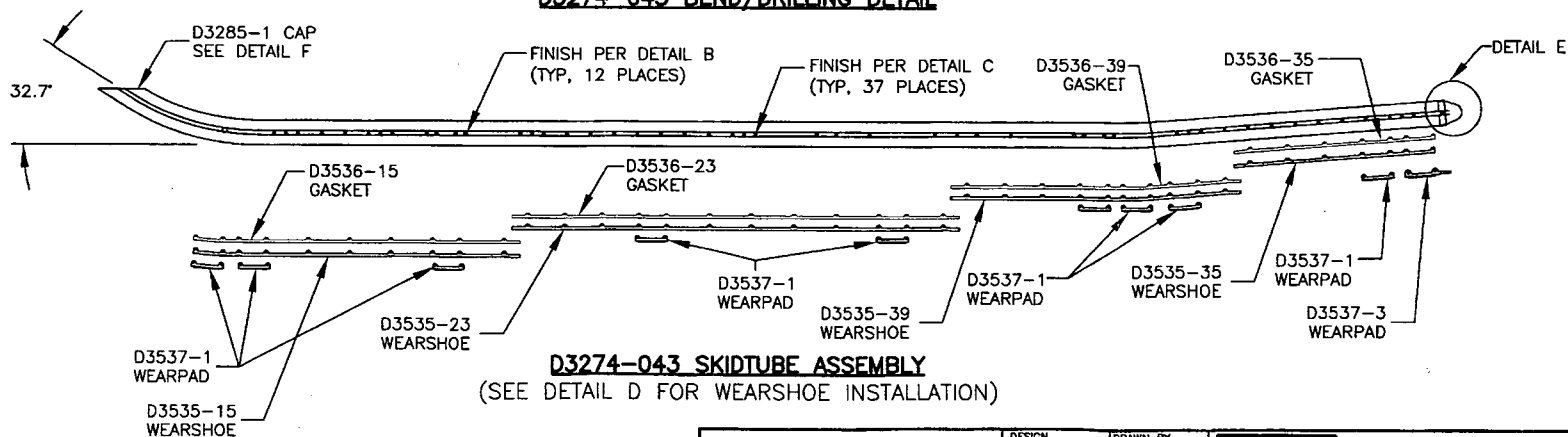
DEO ATTACHED



D3274-043 DRILLING/ASSEMBLY DETAIL



D3274-043 BEND/DRILLING DETAIL



D3274-043 SKIDTUBE ASSEMBLY
(SEE DETAIL D FOR WEARSHOE INSTALLATION)

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07.02.12

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DESIGN	CP	DRAWN BY	PH	DART DART AEROSPACE USA, INC.	REV. D
CHECKED	H	APPROVED	H	PORT HADLOCK, WA	SHEET 3 OF 4
DATE	06.12.19	DRAWING NO.	D3274	TITLE	SKIDTUBE ASSEMBLY
		SCALE			1:15

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

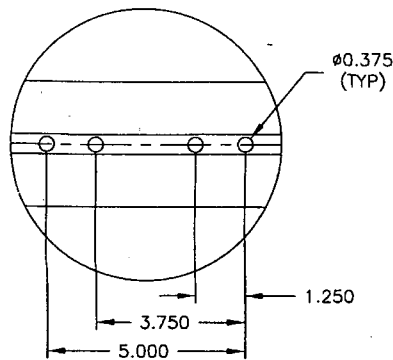
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

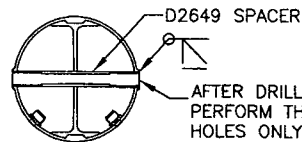
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DETAIL A: DRILL DETAIL

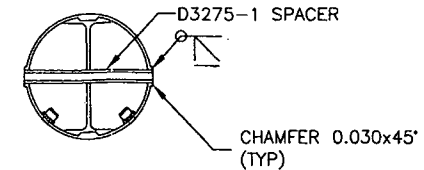


DETAIL B FOR 0.375 HOLES ONLY

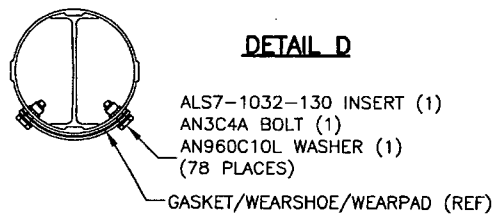


- AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR 0.375
HOLES ONLY:
1. CHAMFER HOLE 0.030x45°
 2. INSERT D2649 SPACER
 3. WELD INTO PLACE AND GRIND FLUSH
 4. C'BORE TO 0.313x0.75 DEEP

DETAIL C FOR 0.313 HOLES ONLY



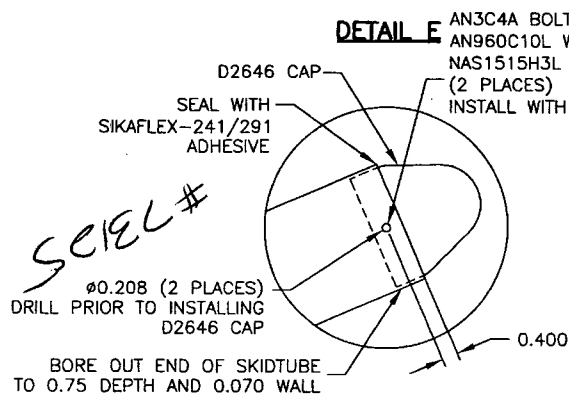
DETAIL D



- ALS7-1032-130 INSERT (1)
AN3C4A BOLT (1)
AN960C10L WASHER (1)
(78 PLACES)

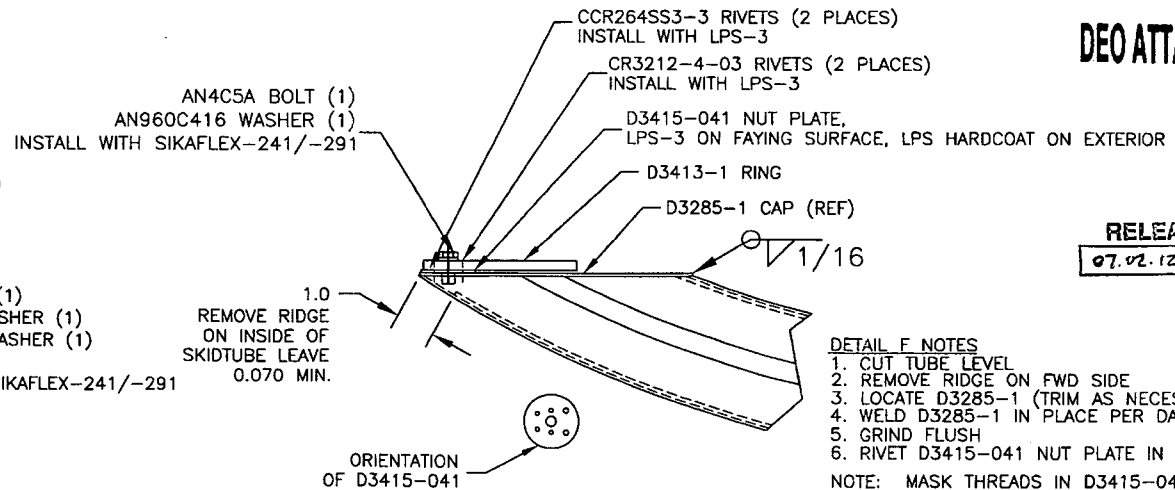
GASKET/WEARSHOE/WEARPAD (REF)

DETAIL E



- AN3C4A BOLT (1)
AN960C10L WASHER (1)
NAS1515H3L WASHER (1)
(2 PLACES)
INSTALL WITH SIKAFLEX-241/-291

DETAIL F: END FINISHING DETAIL



DETAIL F NOTES

1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D3285-1 (TRIM AS NECESSARY)
4. WELD D3285-1 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D3415-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D3415-041
PRIOR TO FINISH

DEO ATTACHED

RELEASED
07.02.12

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--	--	--	---	--	--

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

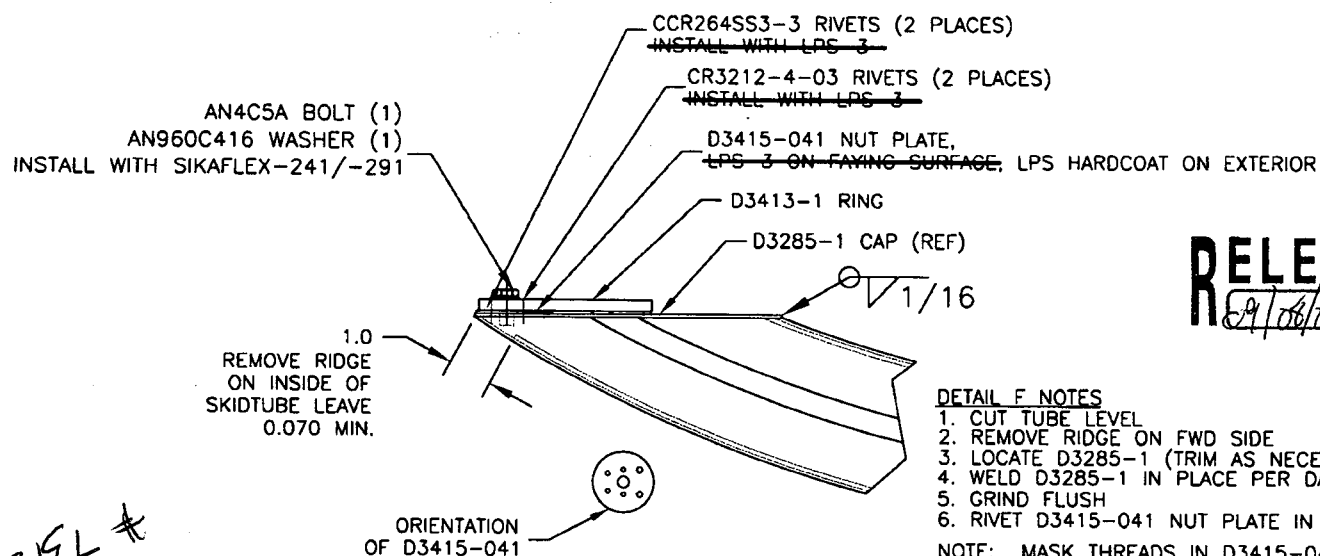
DRAWING NO. D3274	TITLE SKIDTUBE ASSEMBLY	REV. D	DART AEROSPACE USA, INC ENGINEERING ORDER	D.E.O. NO. D3274-D-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>UP</i>	CHECKED <i>L</i>	MFG. APPR. <i>M</i>	APPROVED <i>MP</i>	DE APPR. <i>#</i>		
DATE 09.06.17	DATE 09.06.23	DATE 09/06/23	DATE 09/06/23	DATE 09.06.23		

LPS-3 IS NO LONGER USED DURING ASSEMBLY OF SKIDTUBE.

AMEND NOTE 8: ~~"SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES 'LPS 3' AFTER FINISH AND INSTALLATION OF INSERTS.~~
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES 'LPS PROCYON' AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
POWDER COATING WITH MEK DEGREASER."

AMEND DETAIL F AS SHOWN:

DETAIL F: END FINISHING DETAIL



DETAIL F NOTES

1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D3285-1 (TRIM AS NECESSARY)
4. WELD D3285-1 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D3415-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D3415-041
PRIOR TO FINISH

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

NO. 269

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: B738930
Part number: D206 642 151
Description: 206 skid tube
Welding Process: Tig[☒] Mig[]
Base material: Aluminium
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual:

pass[☒] fail[]

Penetration:

pass[☒] fail[]

UNACCEPTABLE

Cracks:

pass[☒] fail[]

Undercut:

pass[☒] fail[]

Pin holes:

pass[☒] fail[]

Overlap (cold lap)

pass[☒] fail[]

Porosity (surface):

pass[☒] fail[]

Coloration:

pass[☒] fail[]

Qualifier Pat Burns Date of Test Coupon 11.10.07
Welder Barclay Elliott Date of Test Coupon 11.10.07

The above named individual is qualified in accordance with AWS D17.1.2001 to weld